

Work Order ID 162467

Tuesday, June 06, 2017 4:57:33 PM

162467

Page 1

Item ID: D044-713-015 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: R44 Passenger Door Replacement Window, Fits LH or RH
 Start Date: 6/6/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/9/2017 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: *PA* Date: *20170607* Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D044-713	B

JUN 13 2017

DAS
6
9-89

100

Document Control
DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefiles & DT8721 Cutting Template and create labels per PPP
D044-713-015CHG001

DAS
27
9-89

JUN 13 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

JUN 13 2017

DAS
6
9-89

DAS
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

DAS
27
9-89

JUN 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 162467

Tuesday, June 06, 2017 4:57:33 PM

162467

Page 2

Item ID: D044-713-015 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: R44 Passenger Door Replacement Window, Fits LH or RH
Start Date: 6/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/9/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-713-015 LOCATION: FG016								
						DAS 27 9-89			JUN 13 2017
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									
									JUN 14 2017
							DAS 21 9-89		

DAS
21
9-89 JUN 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Monday, June 05, 2017 4:53:57 PM

Page 297

Work Order ID: 162467

162467

Parent Item: D044-713-015

D044-713-015

Parent Item Name: R44 Passenger Door Replacement Window, Fits LH or RH

Start Date: 6/6/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.03.22New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8721 *DT8721* Template		Manufactured	Yes			110	Each	0.0000	1	1			
D2126 *D2126* Locking Seal (Sold Per Foot)		Manufactured	No			110	f	281.9708	6	6.31579			
DAS 27 9-89 DAS 27 9-89 DAS 27 9-89 Location ST414 129650 144146 Loc Qty 281.9707686 0.00000012 281.970768 Loc Code													
D2977 *D2977* Hinge Bracket		Manufactured	No			110	Each	187.0000	1	1			
DAS 27 9-89 Location ST014 14106 19560 Loc Qty 187 8 179 Loc Code													
D3279-1 *D3279-1* Window		Manufactured	No			110	Each	4.0000	1	1			
DAS 27 9-89 Location ST429 84393 Loc Qty 4 4 Loc Code													
MS21042-08 *MS21042-08* USE MS21042L08	MS21042L08	Purchased	No			110	Each	0.0000	1	1			
DAS 27 9-89 Location ST429 84393 Loc Qty 4 4 Loc Code													

JUN 13 2017

JUN 13 2017

JUN 13 2017

JUN 13 2017

137391

Monday, June 05, 2017 4:53:57 PM

Shop Packet Print

Page 297

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-713-011 Crew Door Window Kit	1.5 lb 0.68 kg	±24 in ±0.61 m	±36 in-lb ±0.43 m-kg	66 in 1.68 m	99 in-lb 1.1 m-kg
D044-713-013 Bubble Window Kit, LH	2.5 lb 1.1 kg	-28 in -0.71 m	-70 in-lb -0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-014 Bubble Window Kit, RH	2.5 lb 1.1 kg	+28 in +0.71 m	+70 in-lb +0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-015 Passenger Door Window Kit	1.2 lb 0.54 kg	±23 in ±0.58 m	±28 in-lb ±0.31 m-kg	83 in 2.11 m	100 in-lb 1.1 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Qty -014	Qty -015	Part Number	Description
X				D044-713-011	CREW DOOR WINDOW KIT, (FITS LH & RH)
	X			D044-713-013	BUBBLE WINDOW KIT, LH
		X		D044-713-014	BUBBLE WINDOW KIT, RH
			X	D044-713-015	PASSENGER DOOR WINDOW KIT, (FITS LH & RH)
			1	D2126-0720	SEAL
1	1	1		D2126-0903	SEAL
	1			D3269-1	BUBBLE WINDOW, LH
		1		D3269-2	BUBBLE WINDOW, RH
1				D3277-1	WINDOW
			1	D3279-1	WINDOW
	1	1		D3312-1	PLACARD
			1	D2977	BRACKET
			1	MS21042-08	NUT
*1	*1	*1		DT8720	D044-713-011/-013/-014 CUTTING TEMPLATE (FWD DOOR)
			*1	DT8721	D044-713-015 CUTTING TEMPLATE (AFT DOOR)

* Not to be installed. Cutting template only.

Tuesday, June 06, 2017 4:57:33 PM

Page 1

Quality Control

**Department of Transport**

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH05-13**Issue No.:** 1**Approval Date:** March 18, 2005**Issue Date:** March 18, 2005**Responsible Office:**

Ontario

Aircraft/Engine Type or Model:

ROBINSON R44, R44 II

Canadian Type Certificate or Equivalent:

H-97

Description of Type Design Change:

Replacement Window Kits

**Installation/Operating Data,
Required Equipment and Limitations:**

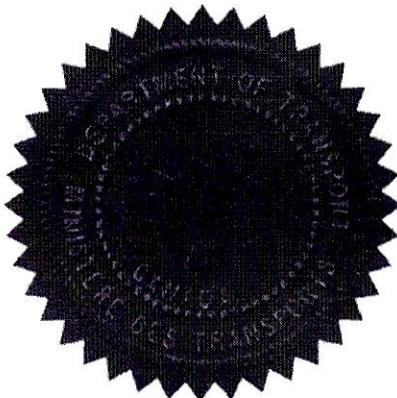
Manufacture of the Replacement Window Kits must be in accordance with Dart Aerospace Ltd. Master Document List, MDL-D044-713, Rev A, approved Mar 11, 2005 or later approved revisions.

Installation of the Replacement Window Kits must be in accordance with Dart Aerospace Ltd. Installation Instructions, IIN-D044-713, Rev A, approved Jan 10, 2005 or later approved revisions.

Maintenance of the Replacement Window Kits must be in accordance with Dart Aerospace Ltd. Instructions for Continued Airworthiness, ICA-D044-713, Rev 0, Transport Canada accepted Mar 18, 2005, or later Transport Canada accepted revisions.

Operations with the Replacement Window Kits installed must be in accordance with Dart Aerospace Ltd. Flight Manual Supplement, FMS-D044-713, Rev A, Transport Canada approved Mar 18, 2005, or later Transport Canada approved revisions.

— End —



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.


M.G. Mariotti
For Minister of Transport